



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3391-013
Job Sheet 178459



Part No: D3391-013

Job Qty: 1 ea

Part Name: Mid Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/29/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV J SHEET 6 IPP A 05.12.13 New Issue EC IPP B IPP Rev:06-03-28 Update Manufacturing Instructions JLM IPP Rev:E ECN 1056 07-11-13 DD verified by: EC IPP Rev:F 08-07-28 chg 0.332" to 0.391" dim. hole in comment DD verified by:EC IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC IPP rev J 10.03.30 revised process, added D3391-015 to pick list EC verified : DD

Ship Via:

Bill of Materials



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S078419



Part: D3391 - 013

Job No: 178459

Serial No/Batch: S078419

Revision:

Inspector:

Exp Date: 06/06/2018

Instructions:

Date: 06/06/18

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/29/18	0.00	0.00	Start Up Skid tubes-1		<i>MB</i>
100	Skid tubes	1 pcs		6/29/18	0.00	2.98	Skid tubes-4		<i>MB</i>
110	QC	1 pcs		6/29/18	0.00	0.00	QC5		<i>15.06.28</i>
120	HandFinish	1 pcs		6/29/18	0.00	0.73	HandFinish1		<i>18-07-02</i>
130	QC	1 pcs		6/29/18	0.00	0.00	QC7-2		<i>BB</i>
140	Skid tubes	1 pcs		6/29/18	0.00	2.98	Skid tubes-3		<i>MB</i>
150	QC	1 pcs		6/29/18	0.00	0.00	QC5		<i>BB</i>
160	Skid tubes	1 pcs		6/29/18	0.00	2.98	Skid tubes-3		<i>MB</i>
170	QC	1 pcs		6/29/18	0.00	0.00	QC10		<i>38 DAS</i>
180	QC	1 pcs		6/29/18	0.00	0.00	QC5		<i>9-89 38</i>
185	HandFinish	1 pcs		6/29/18	0.00	0.73	HandFinish2		<i>18-07-16</i>
190	SprayPaint	1 pcs		6/29/18	0.00	0.63	Spray Paint		<i>JUL 16 2018</i>
200	QC	1 pcs		6/29/18	0.00	0.00	QC14		<i>18-7-19</i>
230	HandFinish	1 pcs		6/29/18	0.00	0.73	HandFinish4		<i>18-7-14</i>
250	HandFinish	1 pcs		6/29/18	0.00	0.73	HandFinish4		<i>18-7-14</i>
260	QC	1 pcs		6/29/18	0.00	0.00	QC5		<i>18-7-19</i>
270	Packaging	1 pcs		6/29/18	0.00	0.00	Packaging3-1		<i>18-7-18</i>
280	QC21-SA	1 Ea		6/29/18	0.00	0.00	QC21		<i>18-7-18</i>

Part Op 100 - Cut tube to finish length as per Dwg D3391 2- Drill pilot holes using DT8796 (Including "B" holes) and drill only 1
 Descriptions: fwd saddle hole on one side only as per Dwg D3391 2- Open saddles and GHW holes to Ø0.4375" except for fwd saddle
 hole 4- Remove .030" from Fwd indexing Ridge as per Dwg D3391 4- Remove indexing ridge on Fwd & Aft end of skid tube
 as per Dwg D3391 6- Drill wearplate holes section L-L only using DT8217, DO NOT open to finish size ***DO NOT DRILL
 HOLES #3-19-20 FROM FWD END OF JIG*** Locating from two fwd wearplate holes in D3391-013 drill remaining 6
 wearplate holes in D3391-011 using DT8937 7- Locate electric step holes at 39.6875" from fwd end and drill using DT 9612
 8- Transfer drill Electric Step holes into D3391-015 locate from wearplate holes. D3391-015 Batch: 5079245
 Deburr, scribe batch # on aft end. 10- Locate D3391-011 in D3391-013 at 9.00" (see view z-z) 11- Transfer drill one fwd
 saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previously drill .188"
 dia hole, using clicos to ensure perfect allignment, open up previously tranfer drilled pilot holes in D3391-013-011 using
 drill press. ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per ON 2ND SIDE ONLY ream
 out 2nd and forth saddle hole to 0.499". D3391-011 BATCH: 5076904 ***DO NOT DRILL HOLES #3-19-20
 FROM FWD END OF JIG*** Locating from two fwd wearplate holes in D
 140 - 1- Prepare for welding 2- Bond web in place as per Dwg D3391 & QSI 015. *****Ensure Web Alignment ***** A/R
 Sikaflex Batch: 432013 Exp. date: 19-03-06
 160 - 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 A/R ALUM Batch: 138834 2-grind weld flush 3-
 Transfer drill electric step pilot holes only from D3391-013 into D3391-015 D3391-015 BATCH: 5079245 4- Open
 electric step holes 0.391" per dwg D3391 (section L-L) 5- Open electric step holes 0.297" per dwg D3391 (section M-M) 6-
 Open electric step holes 0.250" per dwg D3391 (section LL-LL)
 185 - AND REALODINE AS PER PAR09-043
 190 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5084461 PAINT AS PER DWG AND
 QSI005 4.2.2.4 PAINT: 138886
 230 - 1- press fit D3591-1 spacers using DT9416 starting from 0.500" side 2- Install inserts
 250 - Assemble as per dwg D3391

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2500-1-100	Skid tube Extrusion	1 Ea (1 ea)	90-Start up Operation	<i>B163 253</i>
MS27039C4-08	Screw	4 Ea (4 ea)	90-Start up Operation	<i>F1126319</i>
D3389-1	Web	1 Ea (1 ea)	140-Skid tubes	<i>5061828</i>
D3681-1	Spacer	12 Ea (12 ea)	160-Skid tubes	<i>5084724</i>
ALS4-428-165	Insert	4 Ea (4 ea)	230-HandFinish	<i>5058142</i>
D3591-1	Bushing	2 Ea (2 ea)	230-HandFinish	<i>5002403</i>
ALS4-1032-130	Rivnut	26 Ea (26 ea)	250-HandFinish	<i>5007279</i>
D3672-1	Washer, Phenolic	4 Ea (4 ea)	250-HandFinish	<i>F150031</i>
D3672-3	Washer, Phenolic	4 Ea (4 ea)	250-HandFinish	<i>F132639</i>
MS27039C1-09	Screw	4 Ea (4 ea)	250-HandFinish	<i>F11130108</i>
NAS1149C0332R	Washer	4 Ea (4 ea)	250-HandFinish	<i>5056443</i>
NAS1149C0432R	Washer	4 Ea (4 ea)	250-HandFinish	<i>5050052-1</i>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2500-1-100	1	43	0
	MS27039C4-08	4	226	0
140-Skidtubes	D3389-1	1	20	0
160-Skidtubes	D3681-1	12	44	0
230-HandFinish	ALS4-428-165	4	108	0
	D3591-1	2	23	0
250-HandFinish	ALS4-1032-130	26	13,829	0
	D3672-1	4	1,088	0
	D3672-3	4	1,355	0
	MS27039C1-09	4	92	0
	NAS1149C0332R	4	6,681	0
	NAS1149C0432R	4	2,195	0
Part Specifications				
Specifications could not be found.				

Plex 5/31/18 2:23 PM dart.white.jesse

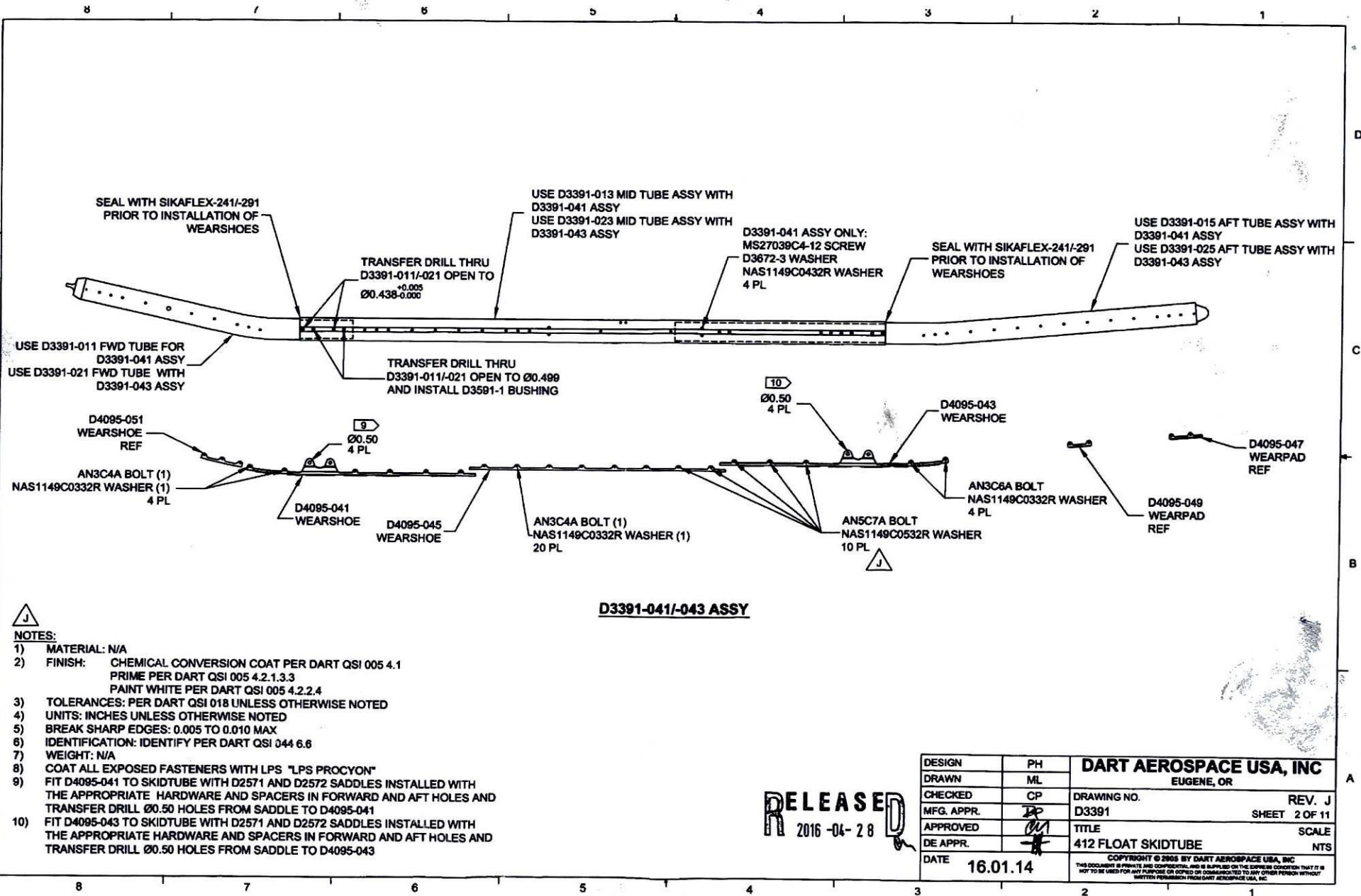
D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

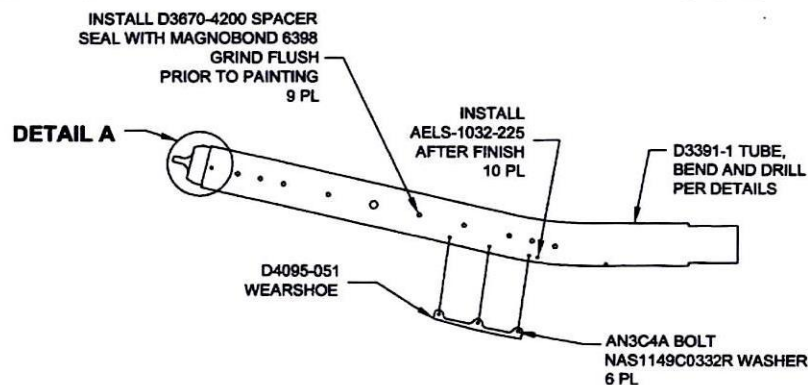
QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
2	2	D3591-1	BUSHING
4		D3672-3	WASHER
1	1	D4095-041	WEARSHOE
1	1	D4095-043	WEARSHOE
1	1	D4095-045	WEARSHOE
1	1	D4095-047	WEARPAD
1	1	D4095-049	WEARPAD
1	1	D4095-051	WEARSHOE
24	24	AN3C4A	BOLT
4	4	AN3C6A	BOLT
10	10	AN5C7A	BOLT
28	28	NAS1149C0332R	WASHER
10	10	NAS1149C0532R	WASHER
4		MS27039C4-12	SCREW
4		NAS1149C0432R	WASHER



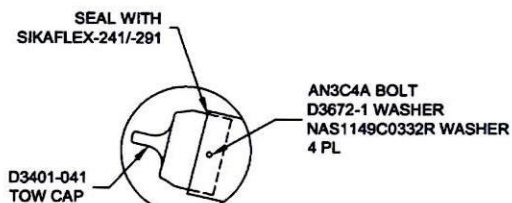
J	INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED CSORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	ML	18.01.14
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C8 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C8 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9384 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	ML		
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	DP	D3391	SHEET 1 OF 11
APPROVED	ELG	TITLE	SCALE
DE APPR.	ST	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

RELEASED
2016-04-28
ECN 16-516

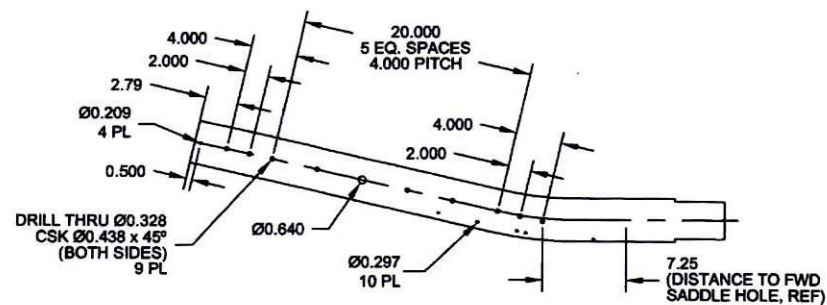




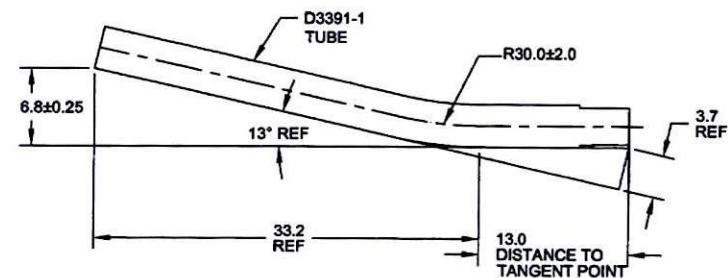
D3391-011 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL



DETAIL A
SCALE 2X



D3391-011 DRILLING DETAIL



D3391-011 BENDING DETAIL
(MAKE FROM D3391-1)

D3391-011 FWD TUBE ASSEMBLY PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D3391-011	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
9	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 3 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2016-04-28

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B



INSTALL
AELS-1032-225
AFTER FINISH
10 PL

D4095-051
WEARSHOE

AN3C4A BOLT
NAS1149C0332R WASHER
6 PL

D3391-021 FWD TUBE ASSEMBLY ASSEMBLY DETAIL

SEAL WITH
SIKAFLEX-241/-291

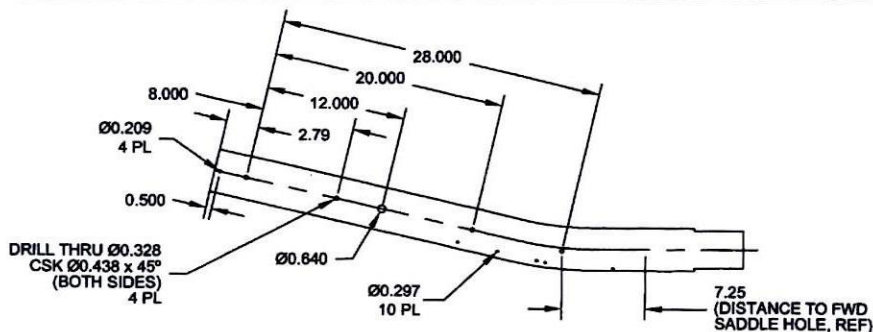
D3401-041
TOW CAP

DETAIL B SCALE 2X

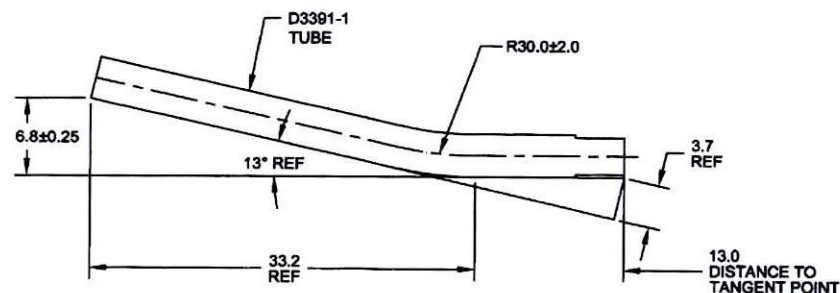
AN3C4A BOLT
D3672-1 WASHER
NAS1149C0332R WASHER
4 PL

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -021	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



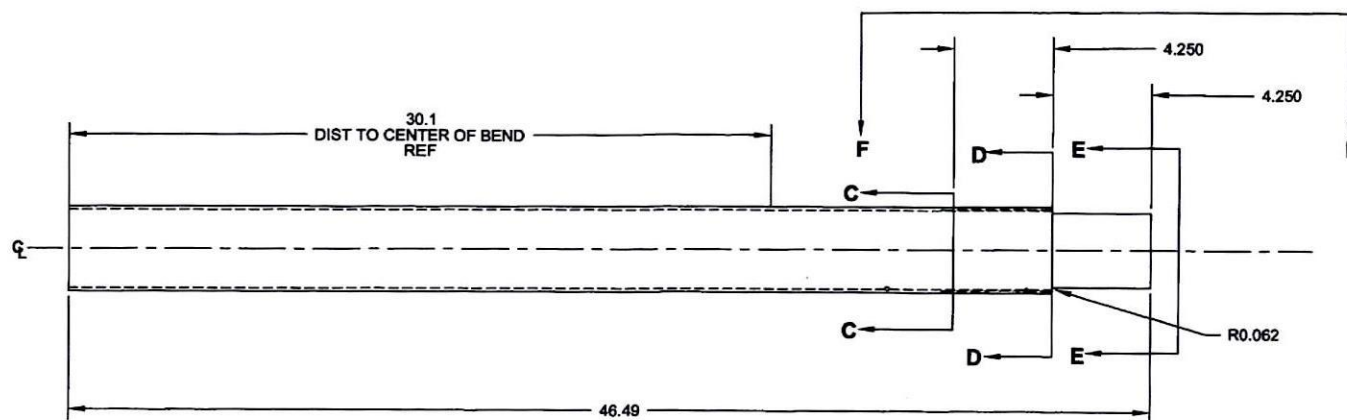
D3391-021 DRILLING DETAIL



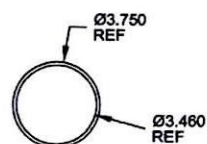
D3391-021 BENDING DETAIL (MAKE FROM D3391-1)

RELEASED
2016-04-28

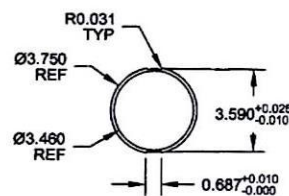
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	TS	D3391	SHEET 4 OF 11
APPROVED	TS	TITLE	SCALE
DE APPR.	TS	412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



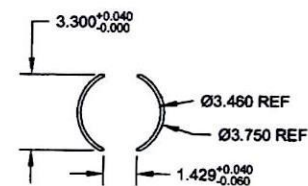
D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



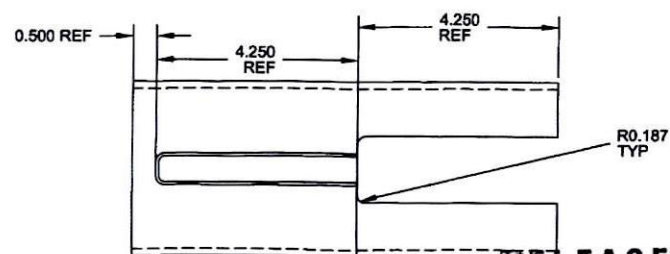
SECTION C-C



SECTION D-D



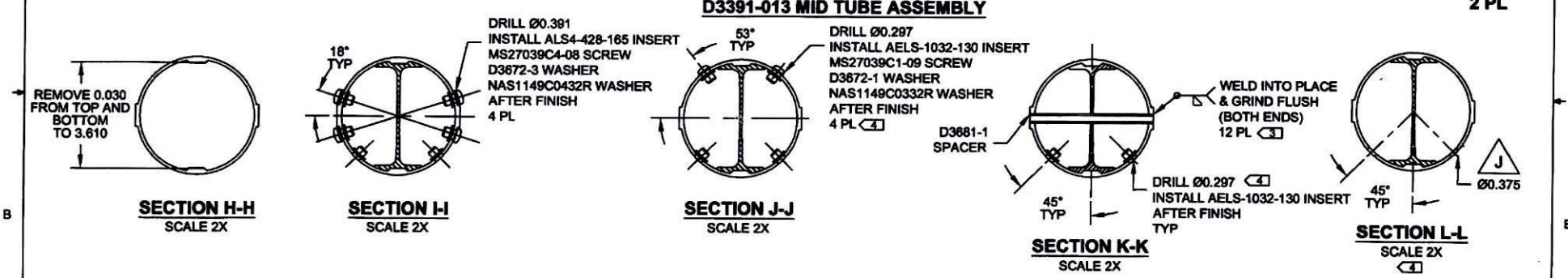
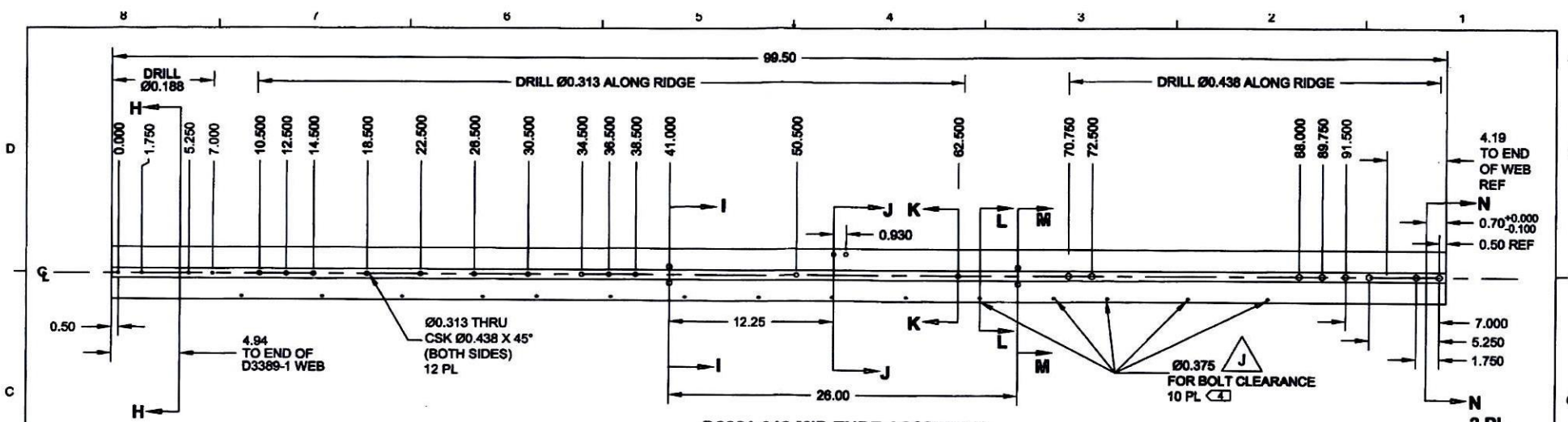
SECTION E-E



VIEW F-F
SCALE 2X

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW
4	NAS1149C0332R	WASHER
4	NAS1149C0432R	WASHER



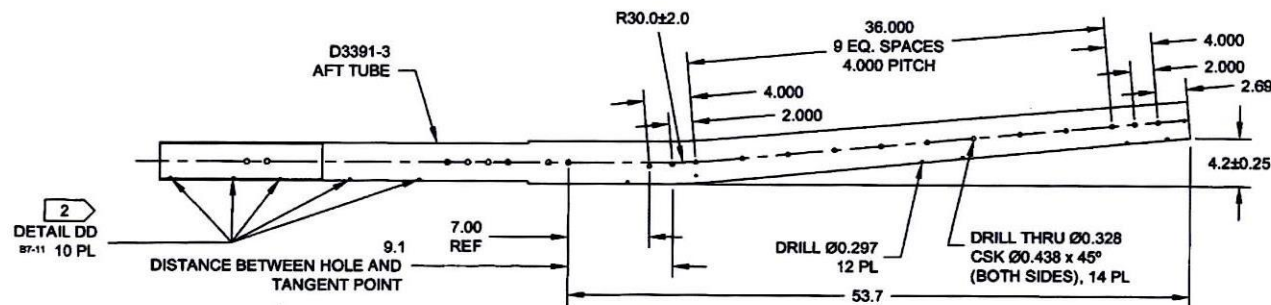
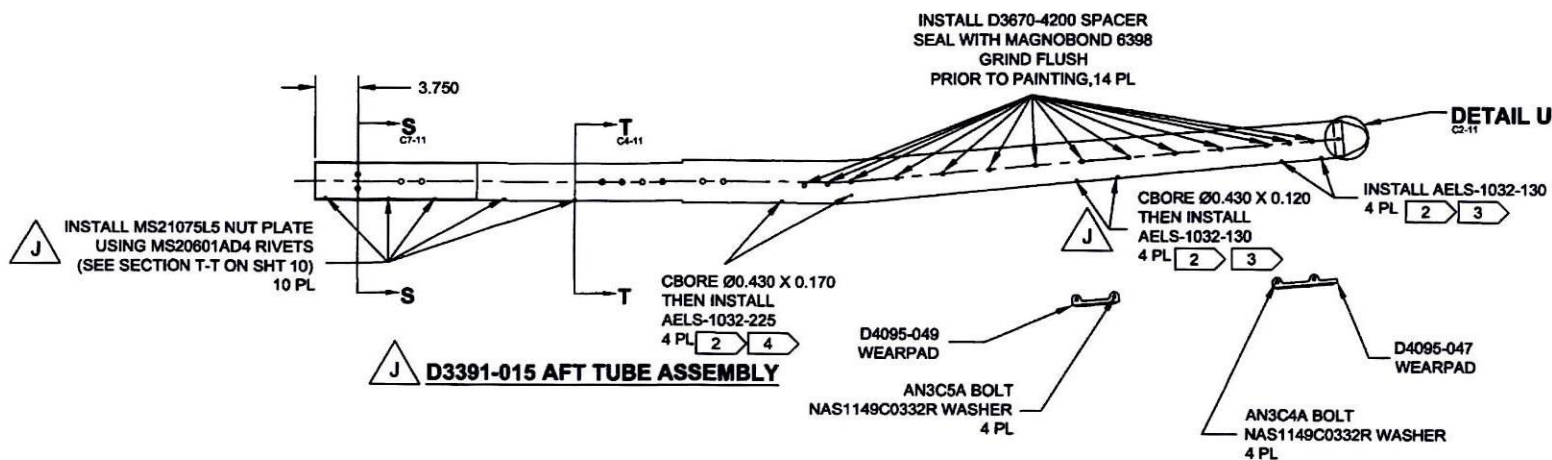
D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

DESIGN	PH
DRAWN	ML
CHECKED	CP
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	16.01.14

DART AEROSPACE USA, INC EUGENE, OR	
DRAWING NO. D3391	REV. J SHEET 6 OF 11
TITLE 412 FLOAT SKIDTUBE	SCALE NTS
COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2016-04-28



D3391-015 AFT TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-015	AFT TUBE ASSEMBLY
1	D2846	AFT CAP
1	D3391-3	AFT TUBE
14	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
4	ALS4-428-165	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE, FLOATING
10	NAS1149C0332R	WASHER

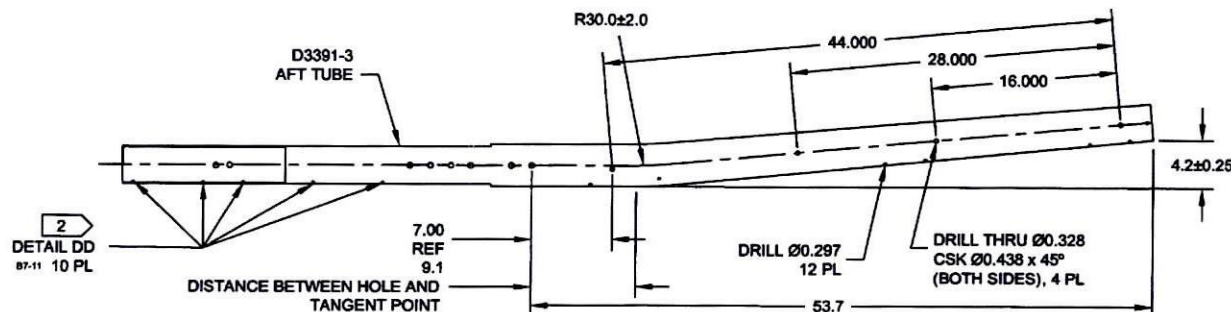
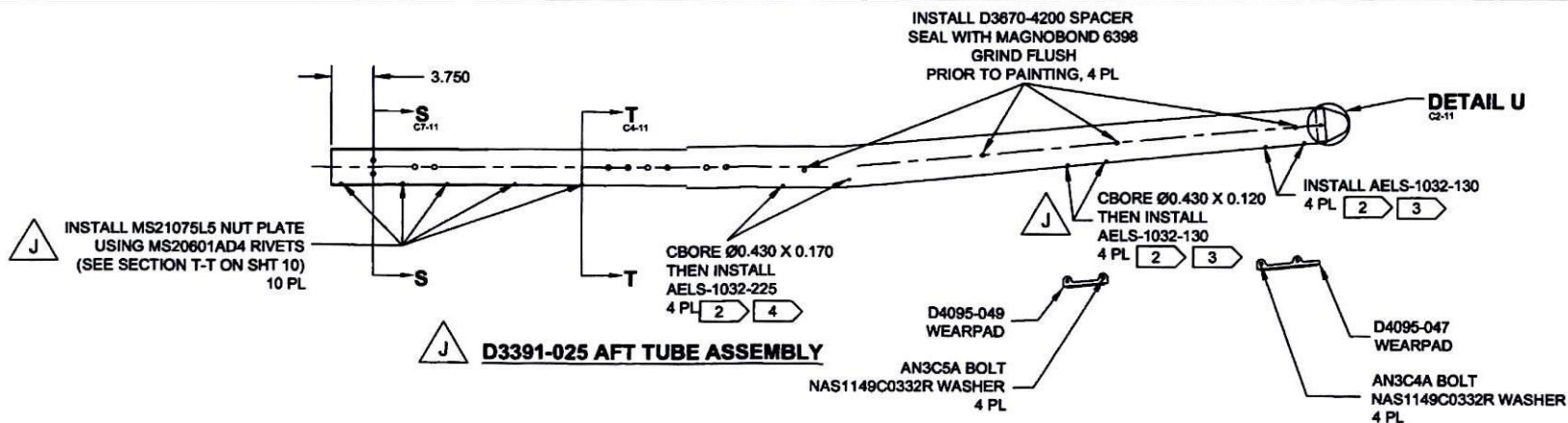
NOTES:

- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

BENDING AND DRILLING DETAIL

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	16.01.14	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D3391-025 AFT TUBE ASSEMBLY PARTS LIST

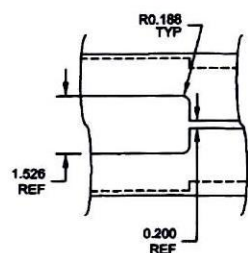
QTY	PART NUMBER	DESCRIPTION
X	D3391-025	AFT TUBE ASSEMBLY
1	D2646	AFT CAP
1	D3391-3	AFT TUBE
4	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE FLOATING
10	NAS1149C0332R	WASHER

NOTES:

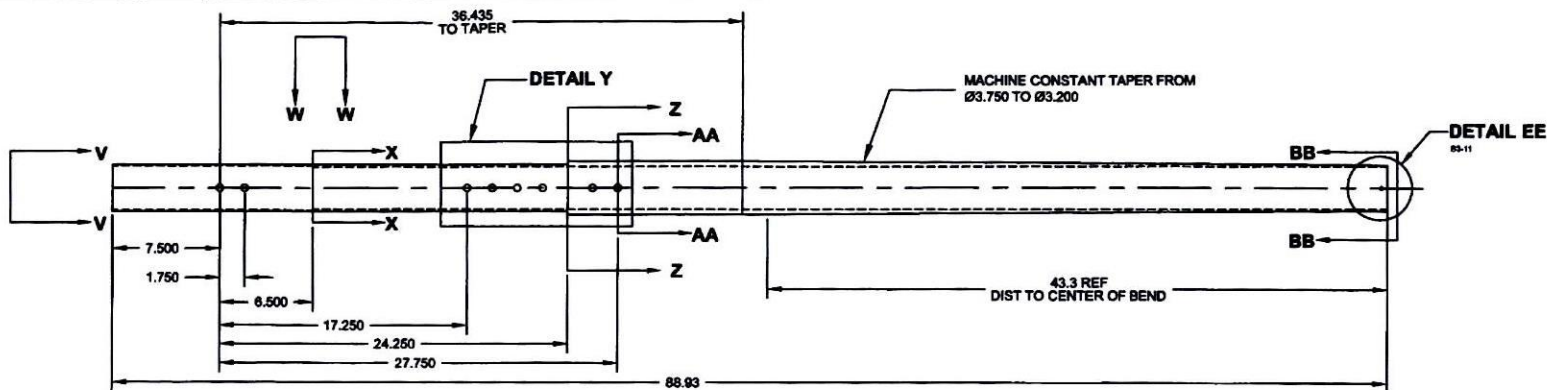
- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED. USE NUT PLATE DRILL JIG IF REQUIRED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

RELEASED
2016-04-28

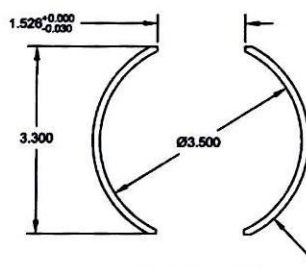
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		AFT TUBE ASSEMBLY	NTS
DATE	16.01.14	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



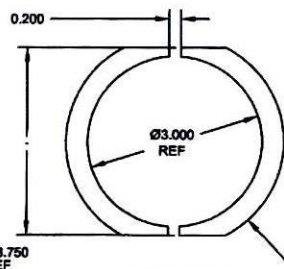
VIEW W-W
SCALE 4X



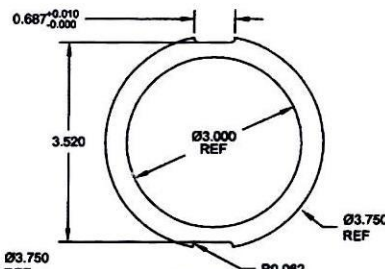
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D8014-090)



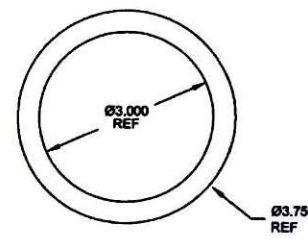
SECTION V-V
SCALE 4X



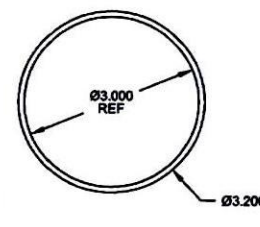
SECTION X-X
SCALE 4X



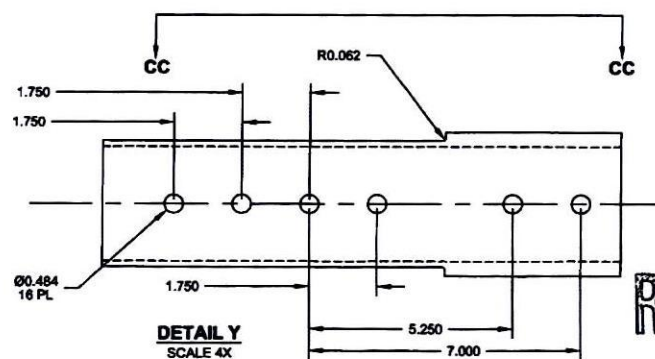
SECTION Z-Z
SCALE 4X



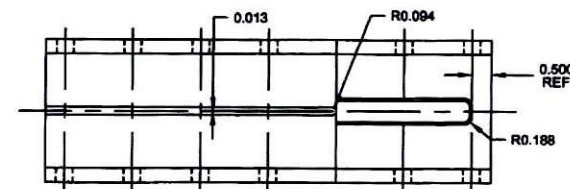
SECTION AA-AA
SCALE 4X



SECTION BB-BB
SCALE 4X



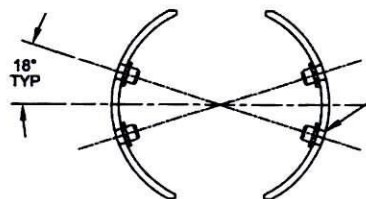
DETAIL Y
SCALE 4X



VIEW CC-CC

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV.
MFG. APPR.	<i>DEF</i>	D3391	SHEET 10 OF 1
APPROVED	<i>CPA</i>	TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NT
DATE	16.01.14	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC	
THIS DOCUMENT IS HEREBY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

RELEASED
2016-04-28

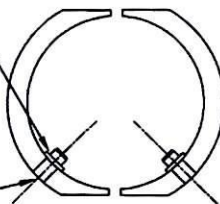


SECTION S-S
SCALE 5X

DRILL $\varnothing 0.391$
CBORE $\varnothing 0.516 \times 0.040$ DEEP
INSTALL ALS4-428-165 INSERT
4 PL

USE DT8217 DRILL TEMPLATE
TO LOCATE HOLES AND OPEN
TO $\varnothing 0.375$

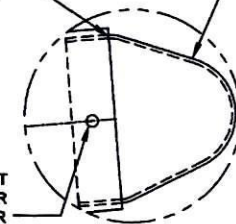
MS21075L5 NUTPLATE
REF



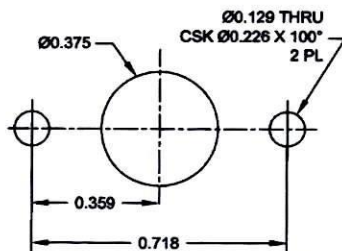
SECTION T-T
SCALE 5X
5 PL

SEAL WITH
SIKAFLEX-241/-291

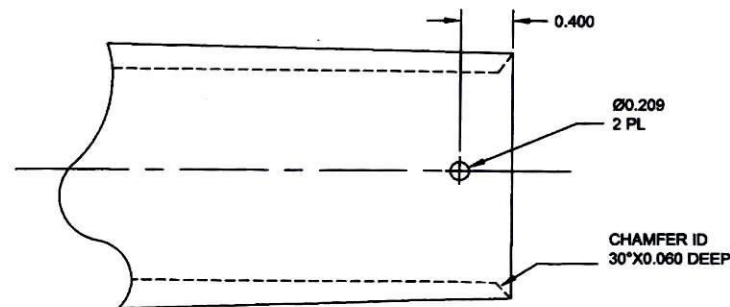
AN3C4A BOLT
D3872-1 WASHER
NAS1149C0332R WASHER
2 PL



DETAIL U
SCALE 5X



DRILLING DETAIL DD
SCALE 10X



DETAIL EE
SCALE 2X

NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

RELEASED
2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	YR	D3391	SHEET 11 OF 11
APPROVED	AN	TITLE	SCALE
DE APPR.	CH	AFT TUBE ASSEMBLY	NTS
DATE	16.01.14	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	